

Work Order ID 60086

June 24, 2010 9:12:31 AM



Page 1

Item ID: D3259-4

Accept



Setup

Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/24/10

Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10

Req'd Qty: 4.00



Customer:

Reference:

Run

Start



Approvals:

Process Plan:

W

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3259

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3259

11Dwg Rev: *B*

11Prog Rev: *B*

112-

Deburr if necessary

2024 . 063

B 10-6-24

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B 10-6-24

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/06/25

(70)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 60086

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Page 2

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Cust Item ID:

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Customer:

Reference:

Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Small Fab

Small Fab

Small Fab

Memo

1-C Sink Holes as per Dwg D3259

0.00

0.00

Sp 10/06/28 (4)

140



Brake NC

NC BRAKE

Brake NC

Memo

Form as per Dwg D3259

0.00

0.00

Sp 10/06/30

(4)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

Sp 10/06/30

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60086

June 24, 2010 9:12:32 AM



Page 3

Item ID: D3259-4

Accept



Setup

Start



Revision ID:

Stop



Item Name: Doubler

Start Date: 6/24/10

Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10

Req'd Qty: 4.00



Customer:

Reference:

Run

Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

4 DL 10-6-30.

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10/06/30

10/06/30

X4 0

180

Identify as per dwg & Stock Location: 180A

0.00



Packaging

Memo

0.00

Packaging

PC/17/01 (4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Work Order ID 60086

June 24, 2010 9:12:32 AM



Page 4

Item ID: D3259-4

Accept



Setup

Start



Revision ID:

Item Name: Doubler

Stop



Start Date: 6/24/10 Start Qty: 4.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 4.00



Customer:

Reference:

Run

Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/07/01 *[Signature]*

MF

10-07-01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 24, 2010 9:12:31 AM

Page 1

Work Order ID: 60086

Parent Item: D3259-4

Parent Item Name: Doubler



Start Date: 6/24/10

Start Qty: 4.00

Required Date: 7/02/10

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.063

Purchased

No

100

sf

122.7000

1.388

5.844211



2024-T3 .063 sheet



1810-6-24

Location

Loc Qty

Loc Code

MAT22

122.7

113866

18.5

114351

104.2

114351

(4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: <i>60086</i>
Description: Doubler		Part Number: D3259-3/-4
Inspection Dwg: D3259	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
10.062	+/-0.010					
9.000	+/-0.005	8.997	✓			
1.000	+/-0.005	.998	✓			
0.260	+/-0.010	.261	✓			
0.900	+/-0.010					
R0.25	+/-0.030	.25	✓			
R0.50	+/-0.030	.50	✓			
5.000	+/-0.005	5.000	✓			
0.875	+/-0.005	.874	✓			
1.300	+/-0.010					
12.000	+/-0.005	12.001	✓			
3.500	+/-0.005	3.500	✓			
0.875	+/-0.005	.872	✓			
R0.13	+/-0.030	.13	✓			
0.500	+/-0.005	.500	✓			
0.525	+/-0.005	.528	✓			
1.80	+/-0.030	1.799	✓			
Ø0.128	+0.005/-0.000	.131	✓			
Ø0.377	+0.005/-0.000	.386	✓			
Ø0.098	+0.005/-0.000	.102	✓			
0.063 thick	+/-0.005	.064	✓			
Grain Direction	N/A		✓			

Measured by: <i>RB</i>	Audited by: <i>S</i>	Preliminary Approval:
Date: <i>10-6-24</i>	Date: <i>10/06/25</i>	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	<i>M</i>

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

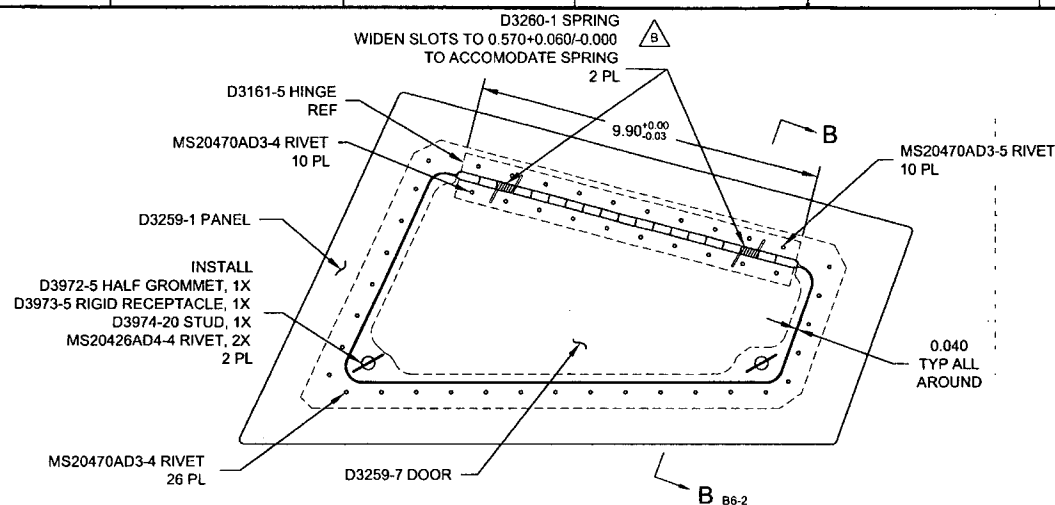
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

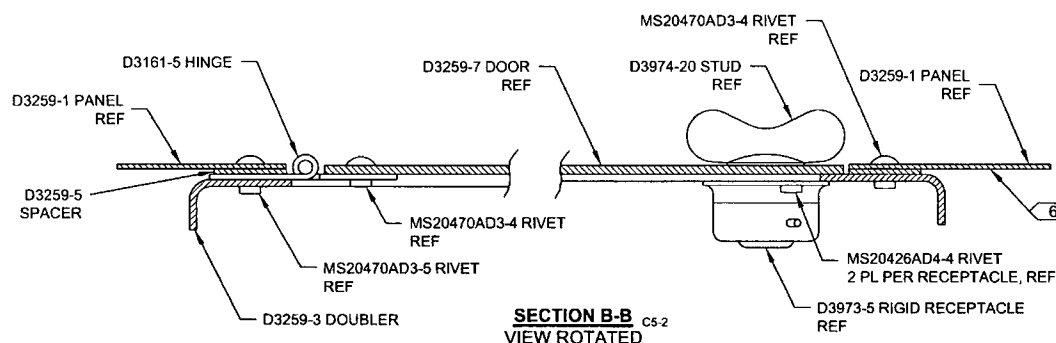
NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



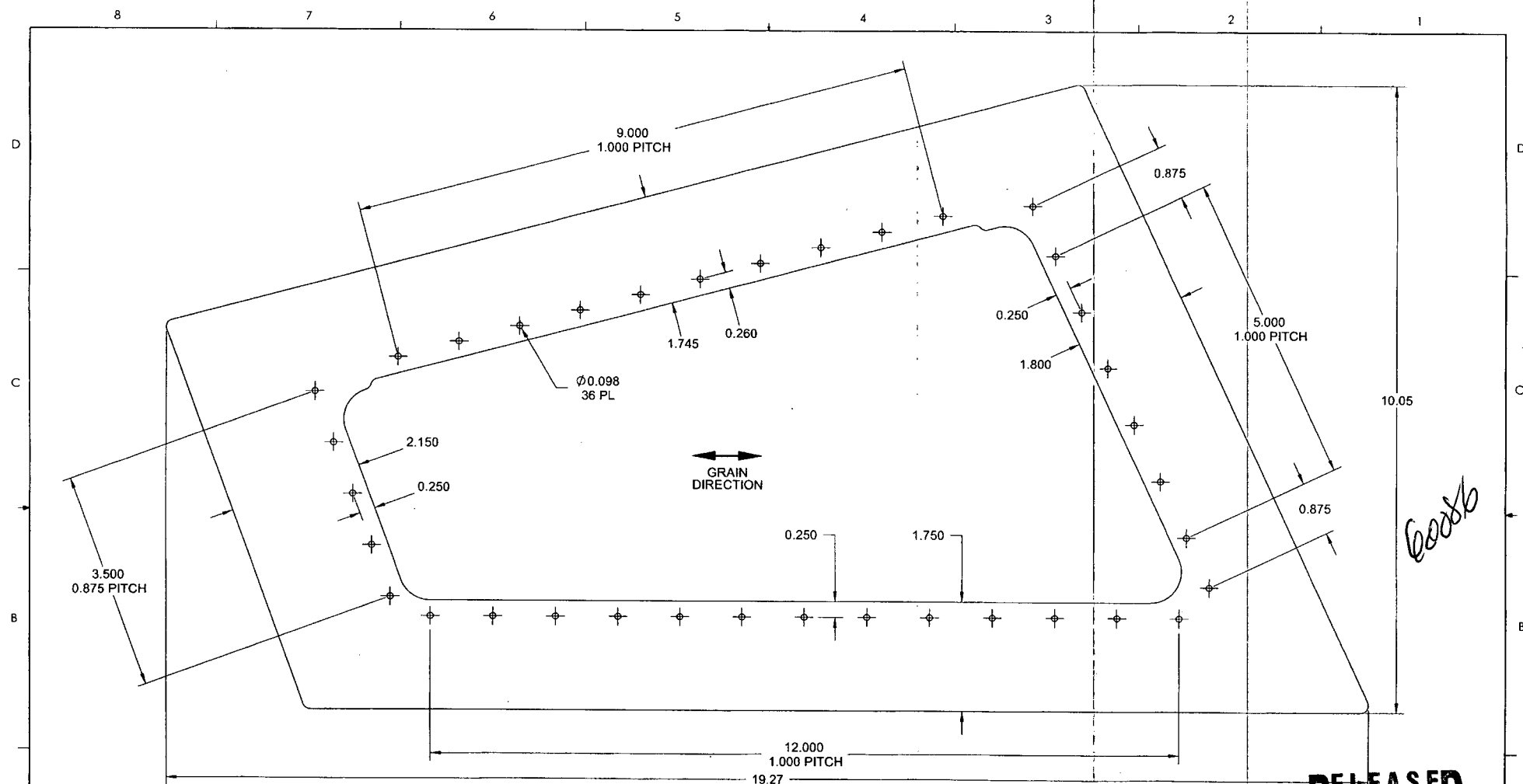
D3259-042 ACCESS PANEL ASSEMBLY

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: NONE
 - 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
 - 7) WEIGHT: 1.2 lbs

RELEASED
2009-10-08

DESIGN	RF	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3259	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		ACCESS PANEL ASSEMBLY	NTS
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8 7 6 5 4 3 2 1



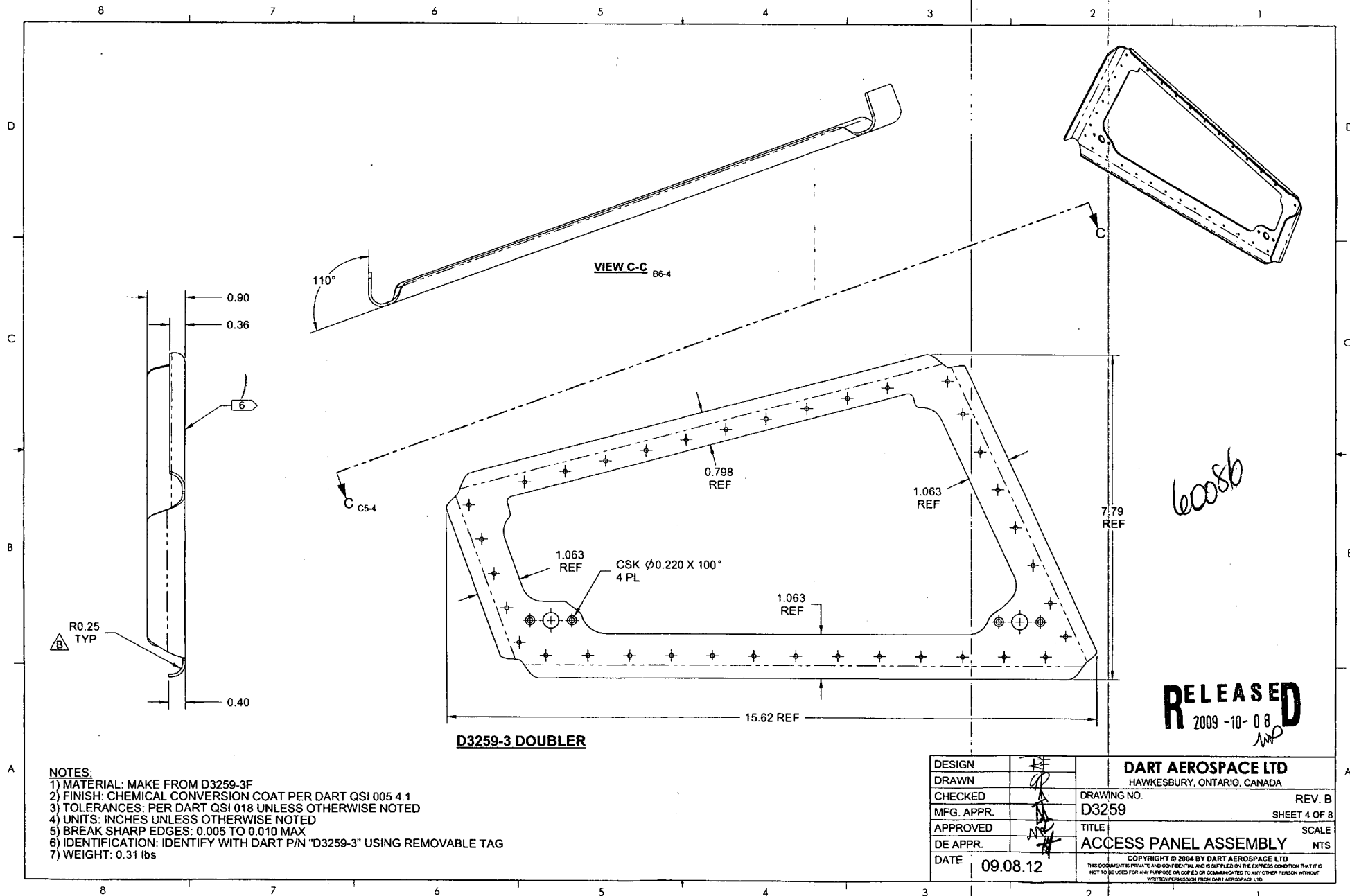
D3259-1 PANEL

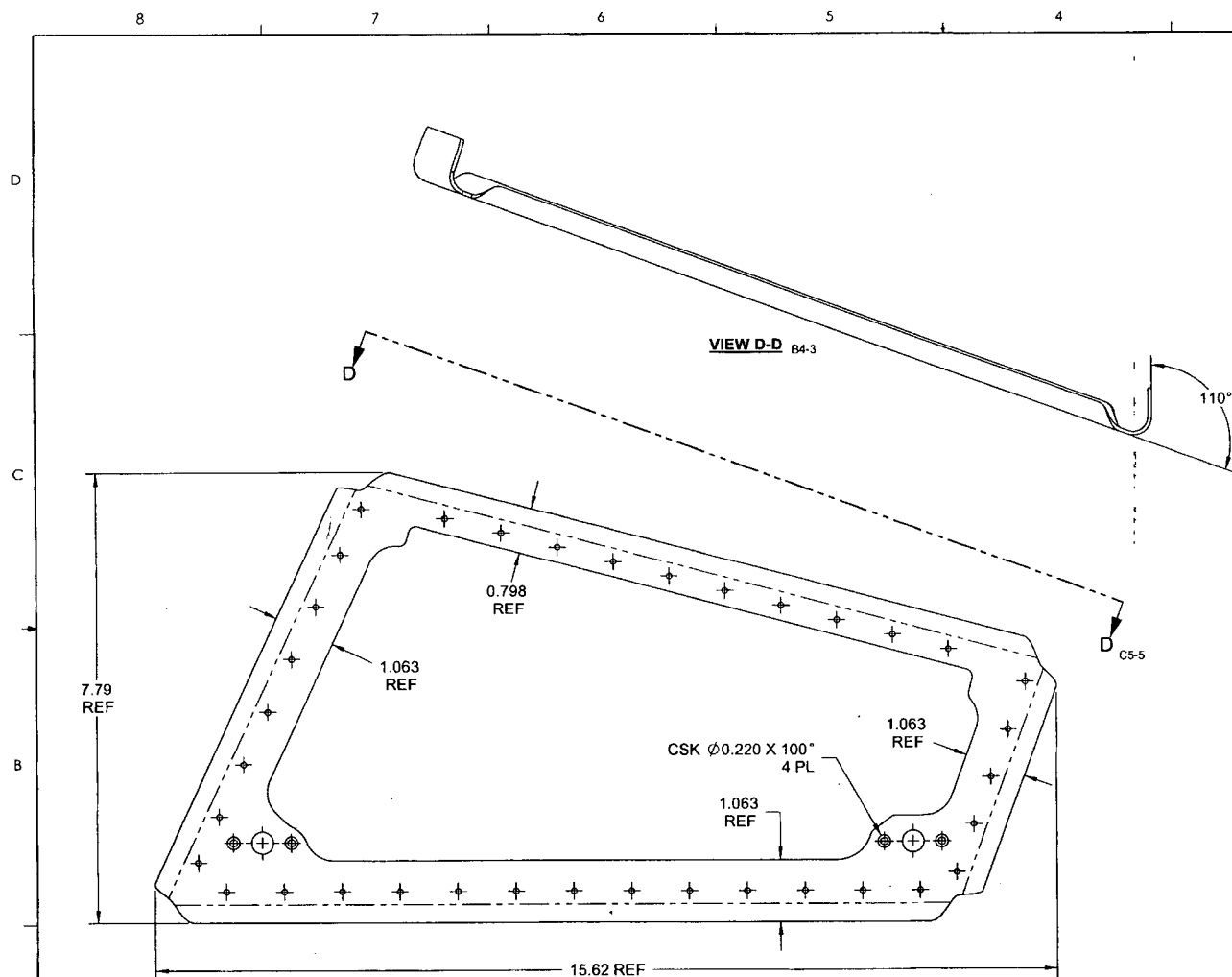
NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-1" USING REMOVABLE TAG
- 7) WEIGHT: 0.25 lbs
- 8) MAKE PER DWG FILE "D3259-1B.DXF"

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2009-10-08
JMD

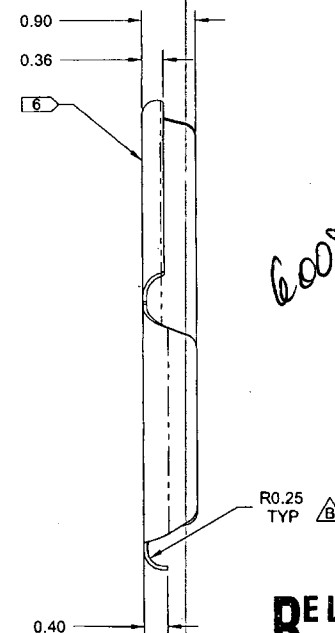
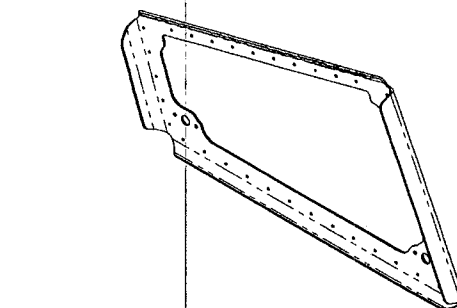




D3959-4 DOUBLER

NOTES:

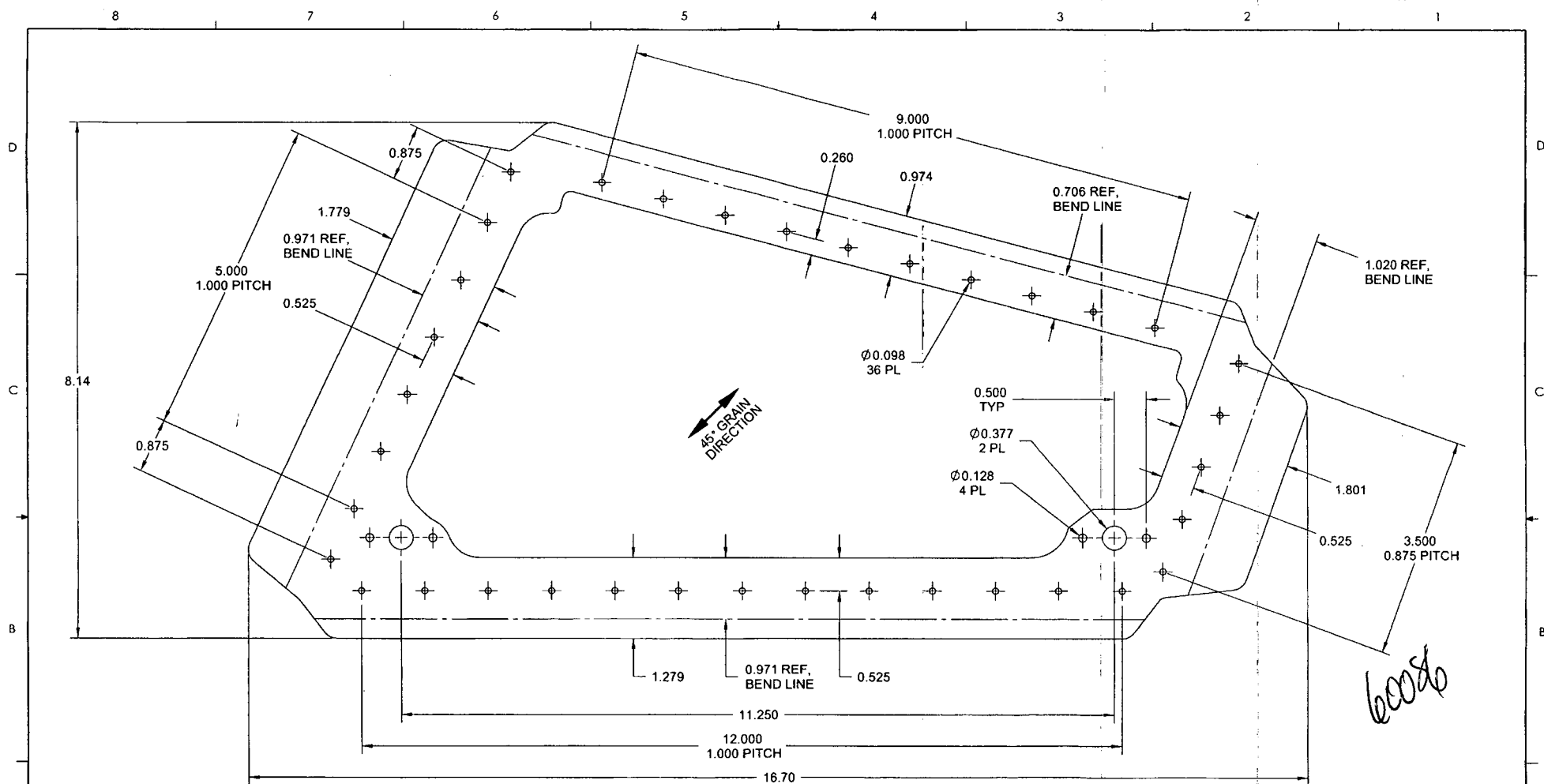
- 1) MATERIAL: MAKE FROM D3259-3F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3959-4" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs



R0.25
TYP

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2009-10-08

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MFG. APPR.			SHEET 5 OF 8
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DE APPR.			NTS
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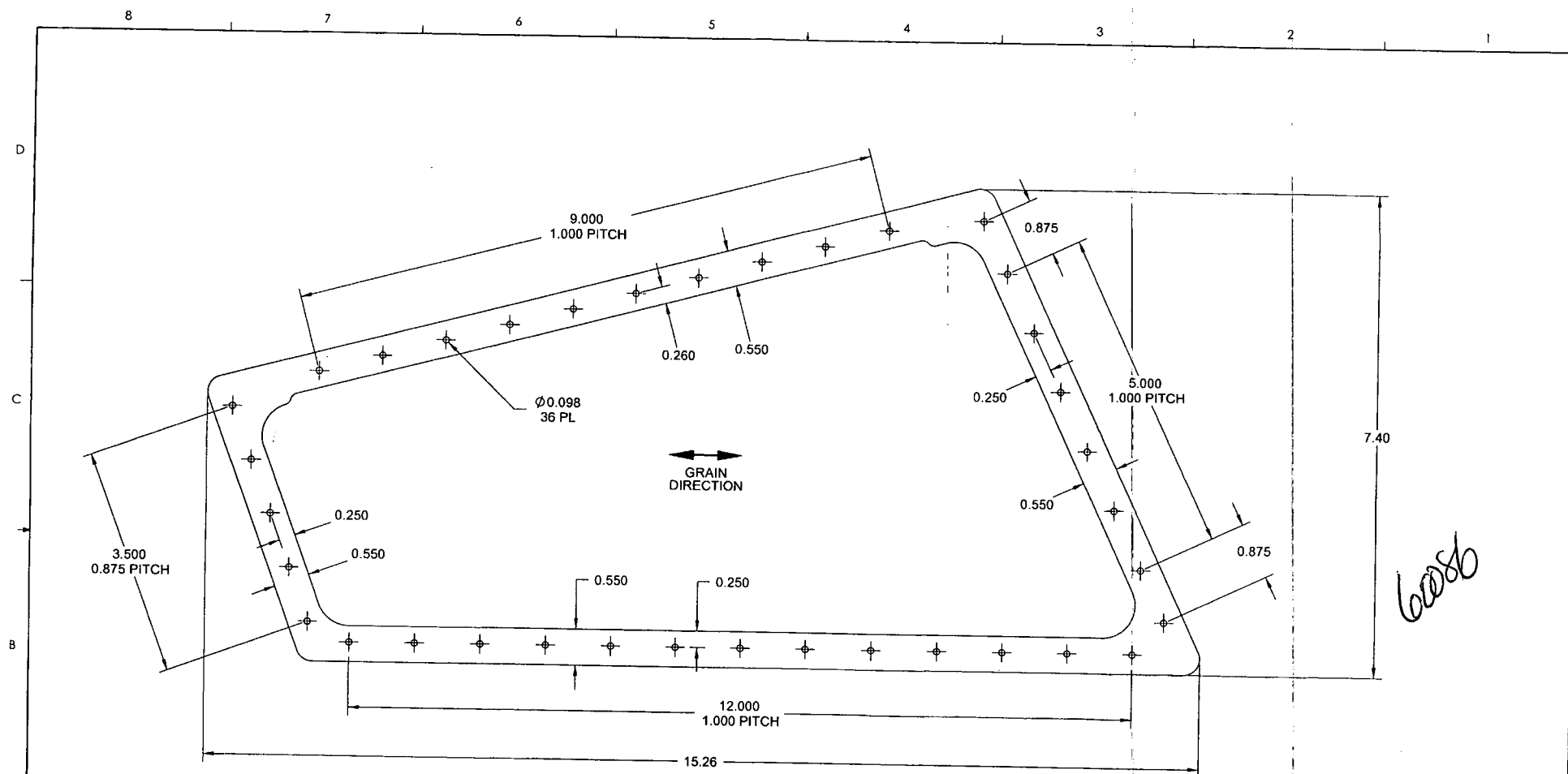
D3259-3F DOUBLER

RELEASED
2009-10-08

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs
- 8) MAKE PER DWG FILE "D3259-3FB.DXF"

DESIGN		DART AEROSPACE LTD	
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MFG. APPR.		D3259	SHEET 6 OF 8
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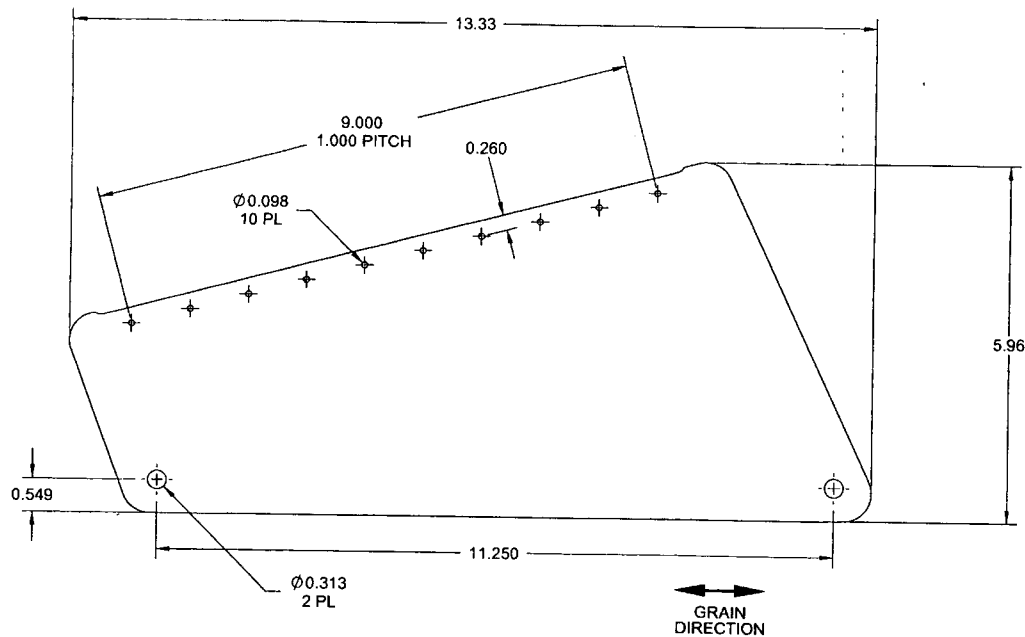
D3259-5 SPACER

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.032 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-5" USING REMOVABLE TAG
- 7) WEIGHT: 0.07 lbs
- 8) MAKE PER DWG FILE "D3259-5B.DXF"

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D3259-7 DOOR

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

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2009-10-08

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3259	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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